

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2015-78 Date Opened: 02-Jul-15 Title: AssemblyAircraft OEM: Bell Aircraft Model: 206L/407 Product Type: Cargo Basket Product Model: Standard Quantity: 5**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JR
JC
JC
JC
N/A
N/A

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

5
N/A
N/A
5

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
N/A
N/A
N/A
JC
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
69811	3	Body	JR
70404	2	Fwd End Mod	JR
69822	1	Aft Hoop	JR
69821	1	End Hoop	JR
49210	2	Hoops	JR

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: J. Rekve for M. RekveSign: SCA: AD01Date: 27-Jul-15

ICC / Dual Inspection performed by:

Print: J. RekveSign: SCA: AD01Date: 27-Jul-15

Work Order closed by:

Print: J. ClarkeSign: SCA: AD02Date: 29-Jun-16

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 69811

Aircraft: Bell

Model: 206L/407

Description: Body Rim

Supplier: Aero Design

Color: N/A

WO#: 2014-59

PO# N/A



Aero Design Ltd.

9888 A Malaspina Rd., Powell
V8A 0G3, 604-483-AERO (2376)

Quantity: 1 Length
PN: 0.5 x 0.5 x .035 wall 4130 Tubing
Aircraft: N/A Model: N/A
Description: 4130 Steel
Supplier: Plymouth Tubing
Color: N/A
WO#: N/A

PO# 14



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 2
PN: 69823-02
Aircraft: 206L/407
Description: Mount Lug
Supplier: Aero Design
Color: N/A
WO#: 2014-70

Model: N/A

PO# N/A

206L/407 STD.

x3 w/cutout
x5 gc.

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

- 69811, Revision 3 – Standard Low Mounted Basket
- 94511, Revision 0 – Extra-Wide Low Mounted Basket
- 94611, Revision 0 – Extra-Wide Low Mounted Ski Basket
- 76611, Revision 0 – High Mounted Ski Basket
- Options → 70404, Revision 2 – Front end cutout – 698
- 70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right

- 77611, Revision 1 – Short Basket
- 76411, Revision 3 – Medium Basket (left or right)
- 78411, Revision 2 – Long Basket
- 94011, Revision 0 – Extra Large (ski) Basket
- Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right

- 90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

- 80211, Revision 0 – Short Basket
- 80311, Revision 0 – Medium Basket
- 81111, Revision 0 – Long Basket
- Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left

- 95911, Revision 0 – Standard Basket

Bell Medium – left or right

- 75111, Revision 0 – Standard Basket
- 95511, Revision 0 – Extra Large (ski) Basket
- Options 70407, Revision 1 – Front end cutout – 751
- 704, Revision – Front end cutout – 955

MD600

- 82811, Revision 0 – Standard Basket

Options – Applicable to all models

- 70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2015-78

Date Open: 02 JULY 2015

1. Rim Assembly – Basket Body

- a. Cut and fit $\frac{3}{4}$ " x 0.035 material to fit rim jig.
 - i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
- b. Record material PO on attached material list.
- c. Remove writing on tubes with acetone and scotch bright.
- d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
- e. 94611 (206L/407 XL ski) only – drill for 4 threaded bushings before assembling rim.

AMC

2. Weld Rim Assembly.

- a. Record welding rod PO on attached material list.
- b. 94611 (206L/407 XL ski) only – weld 4 threaded bushings into inboard rim tube.

AD-05

3. Inspection

- a. Rim for complete welds

OK

4. Frame assembly – body

- a. General
 - i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
- b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
- c. Pull required hoops from stock - standard, attachment, handle.
 - i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
 - ii. Ensure vent hole is located at centre of tube to vent spine tubes.
- d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
 - i. Ensure correct order and orientation of hoops. Refer to drawing.
 - 1. Attachment lugs are on inboard side.
 - 2. Handle bracket bushings are on outboard side, second hoop from both ends. May be on attachment hoops.
 - ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
 - iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
 - iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
 - v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
- e. Cut $\frac{1}{2}$ " x 0.035 material to fit spine jig.
- f. Cut $\frac{1}{2}$ " x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
 - i. Refer to applicable drawing for position, not required on some baskets.
- g. Option: Cut $\frac{1}{2}$ " x 0.035 material for front end cutout. Record material PO on attached material list.
- h. 90611 (R44) only: Cut $\frac{1}{2}$ " x 0.035 material to fit front end structure. Record material PO on attached material list.
- i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

AMC

- j. Record hoop WOs and material POs on attached material list.
- k. Remove writing on tubes with acetone and scotch bright.
- l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
- m. Align hoops to rim in accordance with drawing. General positions:
 - i. Extra large baskets
 - 1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim
 - ii. All other baskets
 - 1. inboard side of hoops (attachment side) aligns to INSIDE of rim
 - 2. outboard side of hoops (handle side) aligns to INSIDE of rim
 - 3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly.

- a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
- b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
- c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
- d. Record welding rod PO on attached material list.

AD-05

6. Inspection

- a. Frame assembly for complete welds.

AD-06

7. Mesh assembly.

- a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
- b. Cut mesh to size for body.
- c. Remove surface rust with scotch-brite.
- d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
 - i. For extra wide baskets only –
 - 1. Set $\frac{3}{4}$ " angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
 - 2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
 - 3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
 - ii. Using markings on table, align sheet to indicated edge.
 - iii. Using markings on table, align 3" tube to required position and clamp tube in place.
 - iv. Bend mesh by hand tightly over tube along length of tube.
 - v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
 - vi. Bend mesh by hand tightly over tube along length of tube.
- e. Install attachment lug jig onto basket frame.

AD-07

- f. Ensure end struts are welded in basket frame if required by the drawing.
- g. Insert mesh into basket.
 - i. General
 1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
 2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
 3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
 4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
 - ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
 - iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
 - iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - v. Clamp mesh to spine in at least 1 place per section.
 - vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
 - vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require $\frac{1}{2}$ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
 - viii. Trim ends to land on hoops, at mesh intersections if possible.
- h. Cut mesh to fit ends. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
 - iv. Cut for front end cutout if required.
- i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
 - i. Remove surface rust with scotch-brite.
 - ii. Ensure mesh is cut at intersections where possible.
 - iii. Bend top edge of mesh 1/4" down at 60 degrees.
 - iv. Fit mesh to front end of basket.

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

AD-05

8. Weld mesh to frame assembly per drawing.
 - a. Ensure lug locating jig is in place prior to welding.
 - b. General welding requirements for all baskets, MIG welding:
 - i. Every intersection at top edges.
 - ii. Every intersection at ends.
 - iii. First 5 intersections down on hoops, then every second intersection.
 - iv. Every intersection along spine.
 - v. Extra large baskets – every intersection along corner.
 - vi. Every intersection around ends
 - vii. Every intersection along struts (if applicable)
 - c. Bend and trim cells bent in to fit mesh as required and weld in position.
 - d. Grind high spots off body mesh welds on ends before welding end mesh.
 - e. 90611 (R44) only – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
 - f. Record welding rod PO on attached material list.

9. Weld basket components

- a. TIG weld lid prop bushing(s), one or two per drawing.
 - i. Record welding rod PO on attached material list.
 - ii. Record lip prop bushing WO on attached material list.
- b. TIG weld caps to close top of 1" hoops as applicable.
- c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
 - i. Cut inboard rim on aft end. Grind flush with hoops.
 - ii. TIG weld caps on open tubes.
 - iii. Record cap material PO on attached material list.
- d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
 - i. Record welding rod PO on attached material list.
 - ii. Record placard bracket WO on attached material list.

AD-05

10. Clean up

- a. Grind high spots off mesh welds.
- b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
- c. Drill #9 through lid prop bushing(s). De-burr hole(s).
- d. Remove surface rust with scotch-brite pad.

OK

11. Final Inspection

To be completed by a different person than the previous steps.

- a. Basket body assembly for complete welds, and required minimum mesh weld locations.
- b. Filled vent holes – usually on hoops
- c. Overall condition and conformity to drawing(s).
 - i. Hoops for height.
 - ii. Rim for width and length and alignment.
 - iii. Lid prop lugs in correct ends.
 - iv. Fore/aft strut in hoop if required by drawing.
- d. Material lists complete.

OK

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)



- e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating

- a. Parts are to be powder coated white in accordance with commercial practices.
- b. Record powder coating PO.
- c. Inspect powder coating on receiving.
- d. Tag basket body assembly and place into stock in preparation for assembly.

Work Order: 2015-78Material Tracking Sheet
Bell 206L / 407
Standard Basket Fabrication

1 of 2

Date Opened: 02 JULY 2015

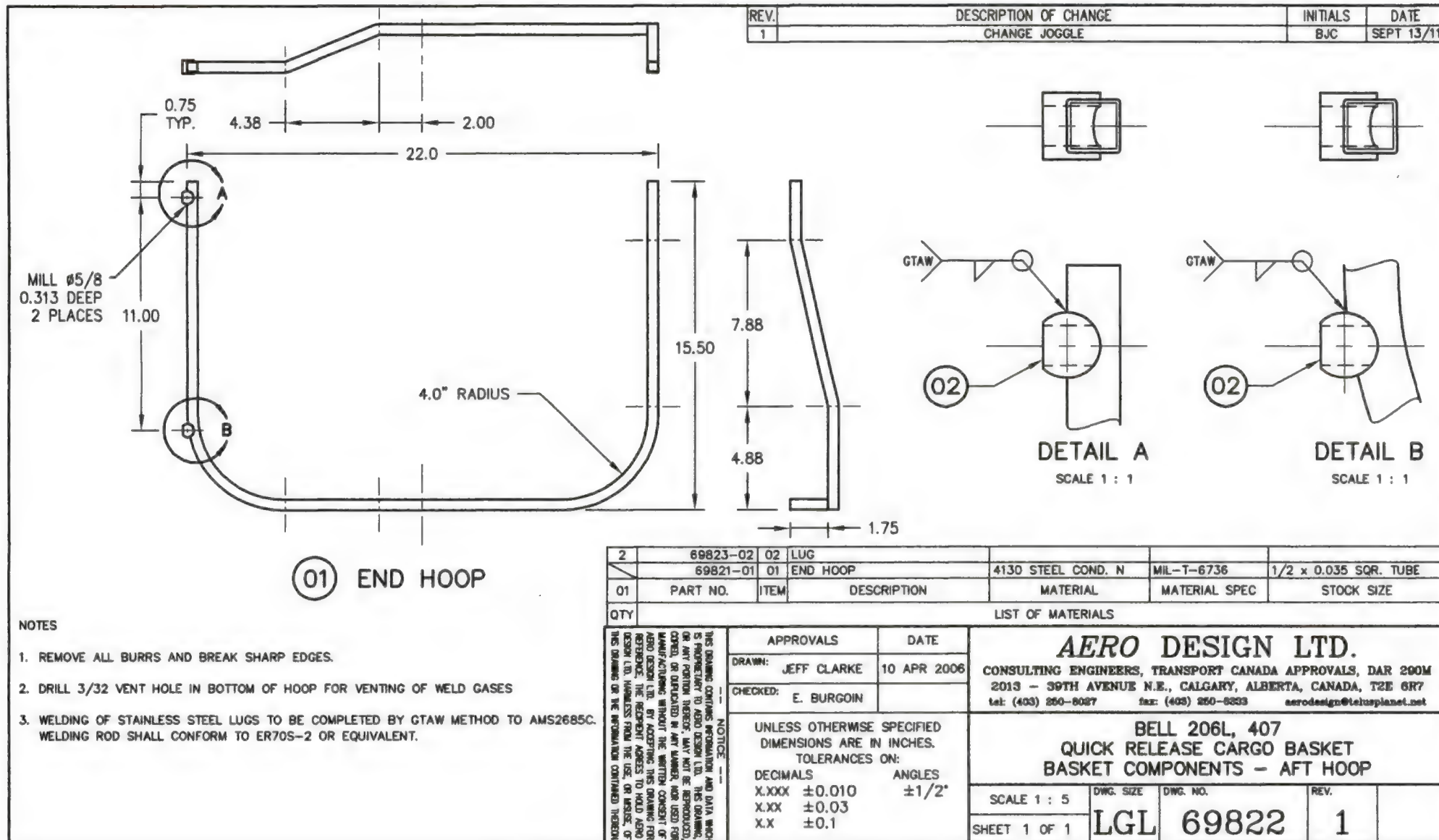
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>5</u>		69811-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		2014-59 p1 complete <i>Rim only</i>
	. 2		--	3/4" Tube - Long Rim (75.75")	4130 Steel, 3/4" x 0.035 Sqr. Tube	14099
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	12123/14099
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 3				<i>Inspection - Rim</i>	None	
Step 4				<i>Frame Assembly</i>		
	. 1		49210-02	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	2015-38 14099 / 15024
	. 2	84262	49210-02	Hoop - with handle provisions	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099 / 15024
	. 1		69821-01	Forward Attachment Hoop		2015-38
	. 1		69822-01	Aft Attachment hoop		2015-38
	. 4		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
	. 2		--	1/2" Tube - strut	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
Step 4.g.		70404	70404-01	Option: Front End Cutout		
(optional)			70404-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
			70404-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	14099
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14033
Step 6				<i>Inspection - Frame Assembly</i>	None	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 48" x 75")	3/4-16F Expanded Mild Steel sheet	14012
	. 2		--	Mesh (End - 22" x 15.5")	3/4-16F Expanded Mild Steel sheet	1402

Work Order: 2015-78Material Tracking Sheet
Bell 206L / 407
Standard Basket Fabrication

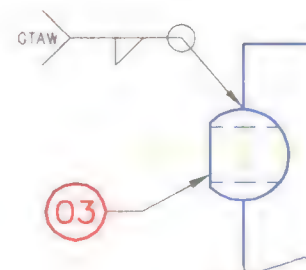
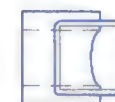
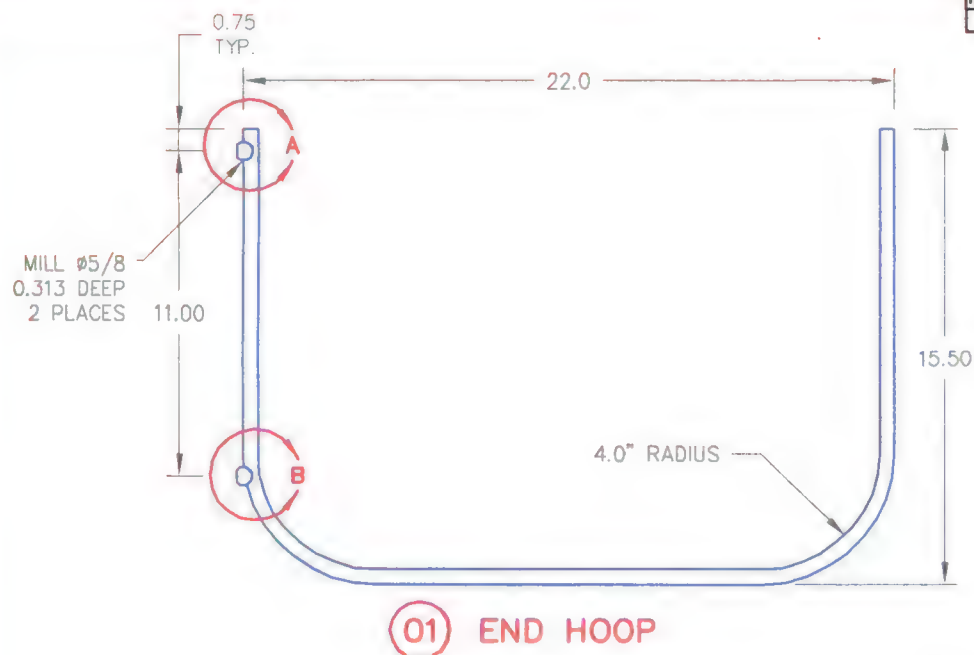
2 of 2

Date Opened: 02 JULY 2015

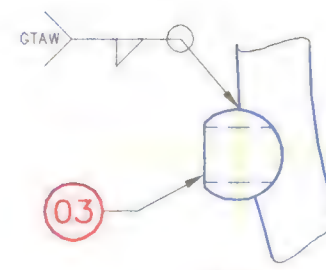
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				Weld Mesh		
	A/R		--	Welding Rod	ER70S-6 MIG Wire	14028
Step 9				Weld Basket Components		
	. 1		49215-01	Spacer (Lid prop)	304 Stainless Steel, 1/2" Dia.	2014-38
	A/R		--	Welding Rod	ER308L TIG Rod	14028
Step 10				Clean Up	None	
Step 11				Inspection - Final Assembly	None	
Step 12				Powder Coating		



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVED LUG (ITEM 2), BOTH LUGS NOW ITEM 3	BJC	09/11/2006



DETAIL A
SCALE 1 : 1



DETAIL B
SCALE 1 : 1

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL 3/32 VENT HOLE IN BOTTOM OF HOOP FOR VENTING OF WELD GASES
3. WELDING OF STAINLESS STEEL LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS 5680 (347 STAINLESS STEEL) OR EQUIVALENT.

2	69823-02	03	LUG	304 STAINLESS STEEL	ASTM A476	5/8 DIA ROD
	--	02	--			
	59821-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

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APPROVALS	DATE
DRAWN: JEFF CLARKE	10 APR 2006
CHECKED: E. BURGON	

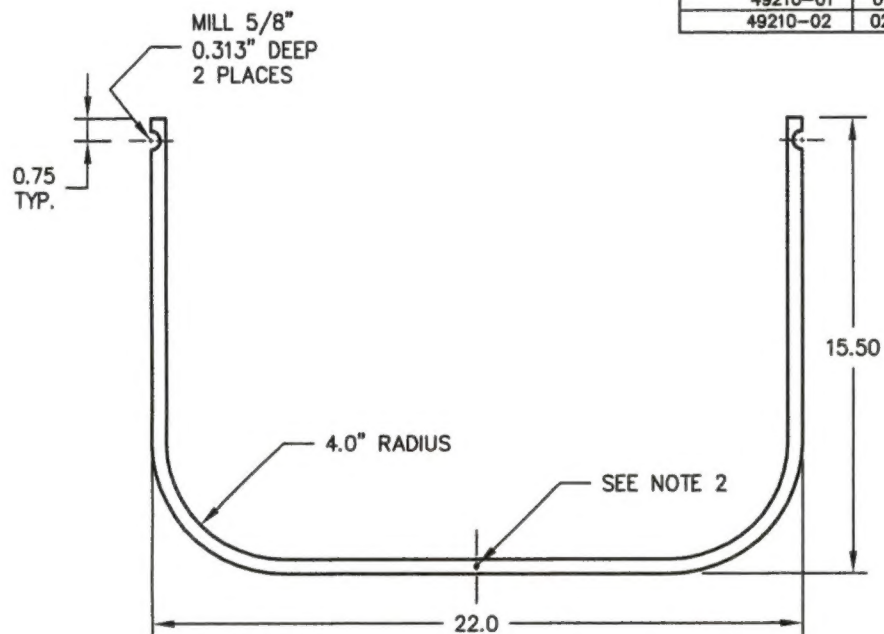
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1

AERO DESIGN LTD.
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M
2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7
tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net

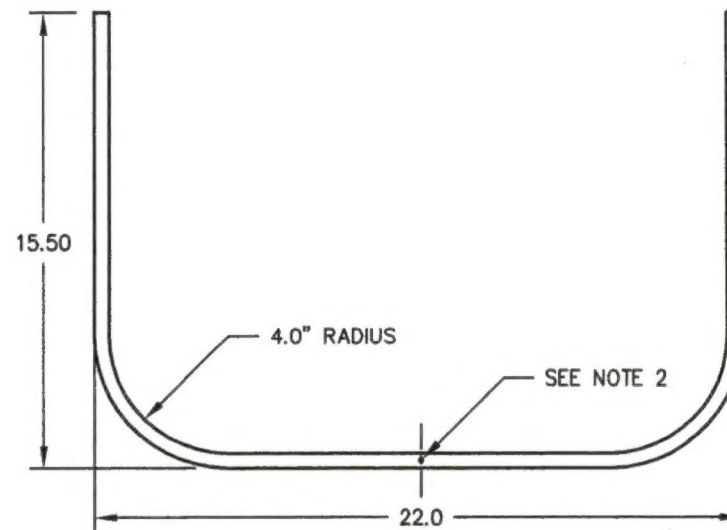
**BELL 206L, 407
QUICK RELEASE CARGO BASKET
BASKET COMPONENTS - END HOOP**

SCALE 1 : 5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	LGL	69821	1

LIST OF MATERIALS					
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
49210-01	01	END HOOP	4130 SQUARE TUBING	MIL-T-8736	#1/2" x 0.035 WALL
49210-02	02	HOOP	4130 SQUARE TUBING	MIL-T-8736	#1/2" x 0.035 WALL



01 END HOOP



02 HOOP

NOTES:

1. REMOVE ALL BURRS AND SHARP EDGES.
2. DRILL #30 (0.129) VENT HOLE IN BOTTOM OF HOOPS FOR VENTING WELD GASES.

2	TITLE BLOCK UPDATED; VENT HOLE CHANGED	BJC	22/05/2014
1	HOOP HEIGHT CHANGED	BJC	APR 28/04
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE

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APPROVALS	DATE
DRAWN: STEVEN FAHEY	MAY 10/02
CHECKED: E. BURGON	MAY 10/02



AERO DESIGN LTD.

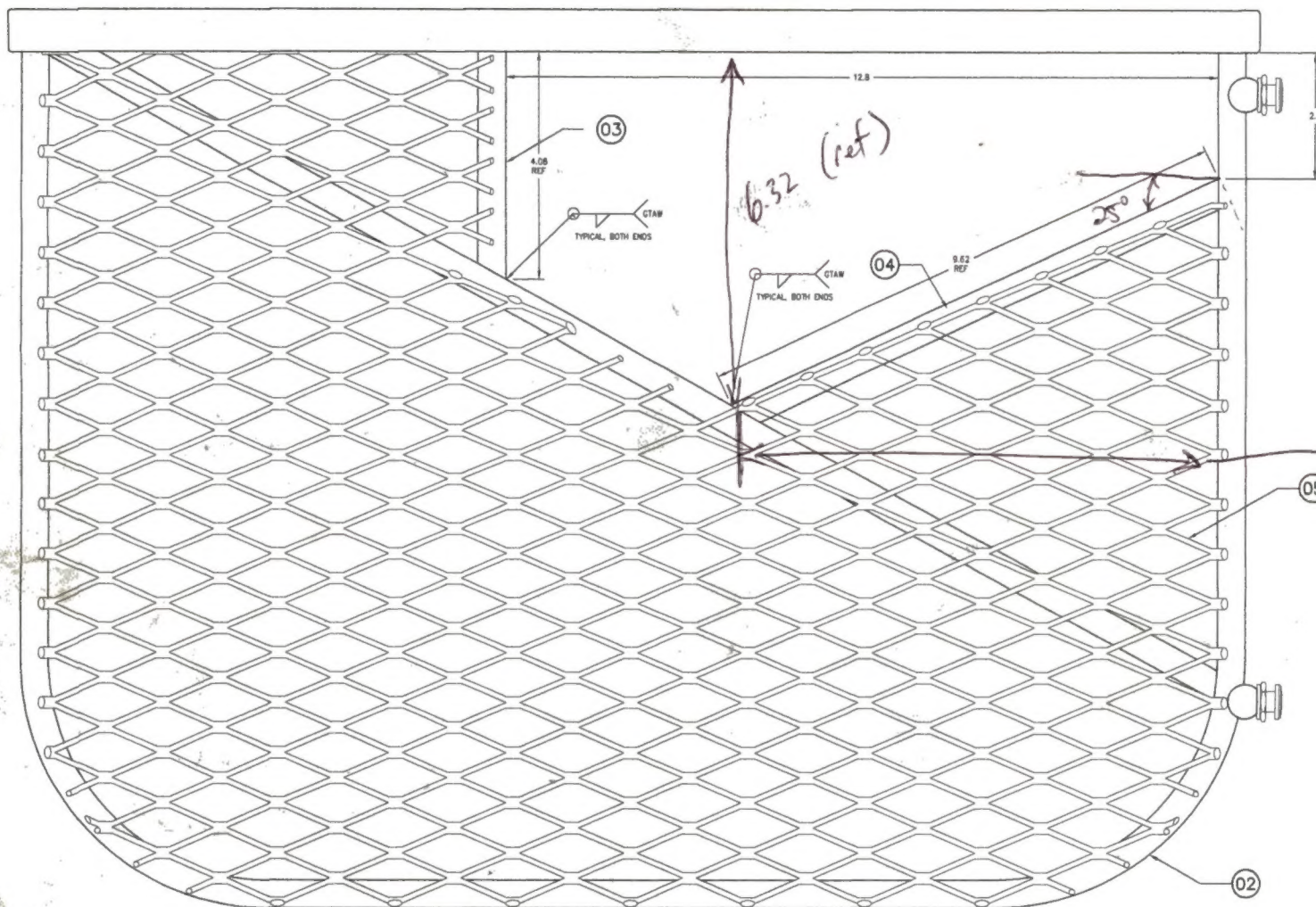
9888A MALASPINA ROAD
POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.2376 www.aerodesign.ca

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

HELICOPTER CARGO BASKET
BASKET COMPONENTS - HOOPS

SCALE 1 : 5	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	LGL	49210	2

REV		DESCRIPTION OF CHANGE	INITIALS	DATE
1		OPENING MODIFIED	BJC	JAN 19/06
2		OPENING MODIFIED	BJC	OCT 27/11



01 BASKET BODY ASSEMBLY

NOTES

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION FOR THE FORWARD END ONLY. REMAINDER OF BASKET IS TO BE IN ACCORDANCE WITH DRAWING 69811.
2. REMOVE ALL BURRS AND BREAK SHARP EDGES
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
4. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1		3/4-16F 05	MESH	MILD STEEL	COMMERCIAL	
1	70404-04	04	TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 WALL TUBE
1	70404-03	03	TUBE	4130 STEEL COND. N	MIL-T-8736	0.5 X 0.035 WALL TUBE
1	69811-01	02	BASKET BODY ASSEMBLY			
1	70404-01	01	BASKET BODY ASSEMBLY - MODIFIED FORWARD END			

LIST OF MATERIALS

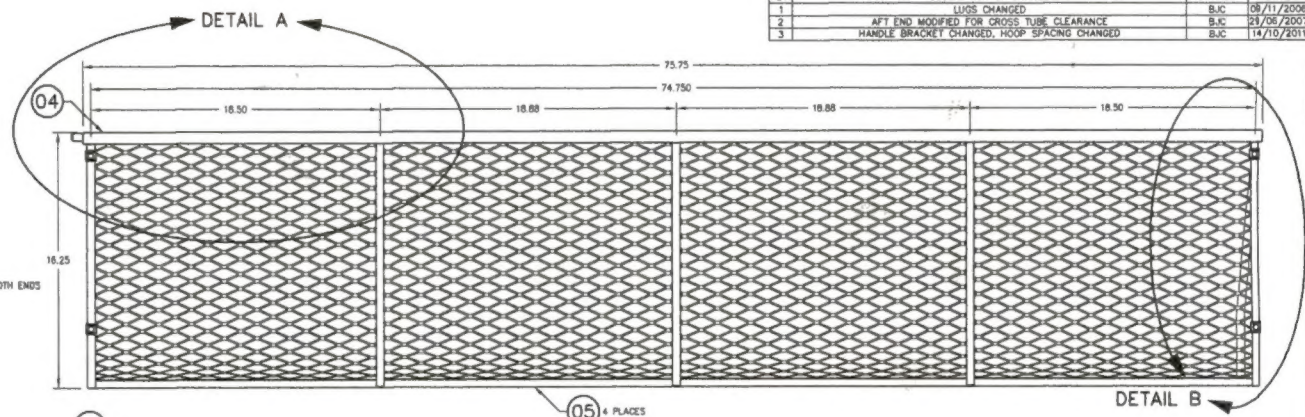
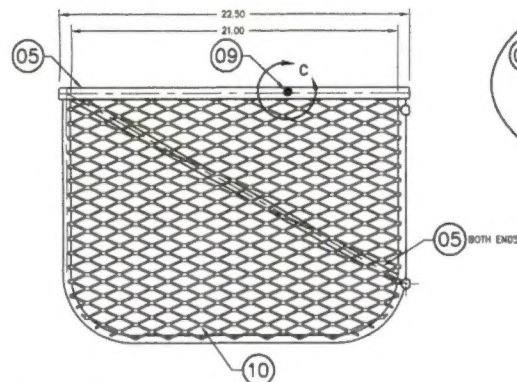
APPROVALS		DATE
DRAWN	JEFF CLARKE	06 SEPT 2006
CHECKED	E. BURGOIN	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:		
DECIMALS	ANGLES	
X.XXX ±0.010	±1/2°	
X.XX ±0.03		
X.X ±0.1		
SCALE 1 : 1		
SHEET 1 OF 1	A1	70404 2

AERO DESIGN LTD.

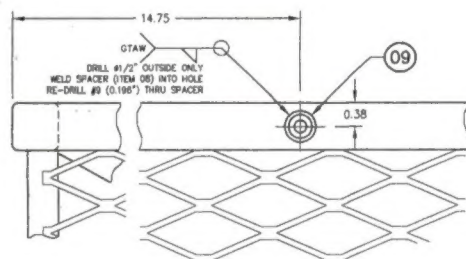
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAB 500M
2013 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 0B7
tel: (403) 260-0007 fax: (403) 260-0333 info@aerodesign.ca

BELL 206L AND 407
QUICK RELEASE CARGO BASKET
OPEN FORWARD END MODIFICATION

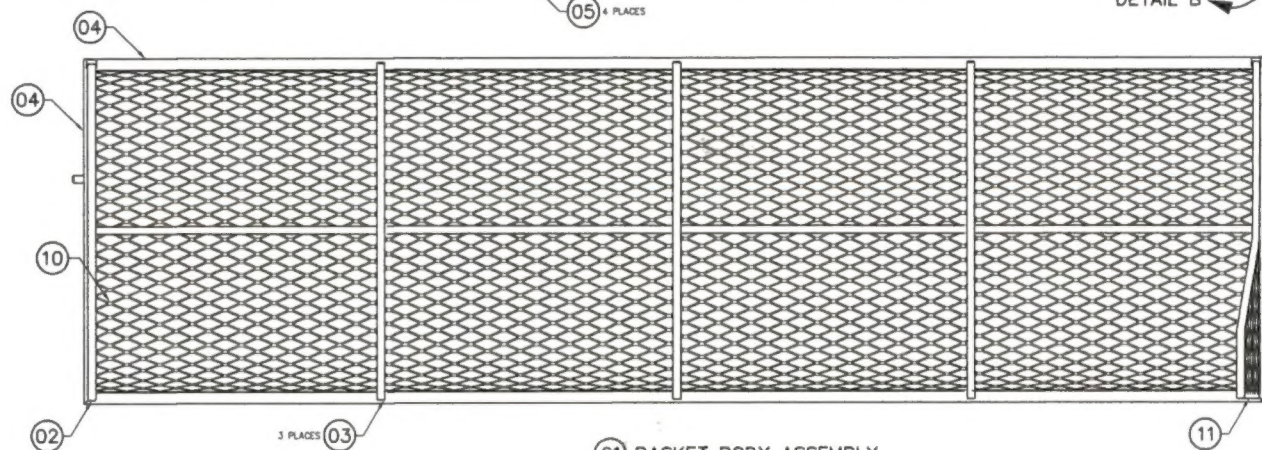
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REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	LUSS CHANGED	BJC	08/11/2006
2	AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	28/05/2007
3	HANDLE BRACKET CHANGED, HOOP SPACING CHANGED	BJC	14/10/2011



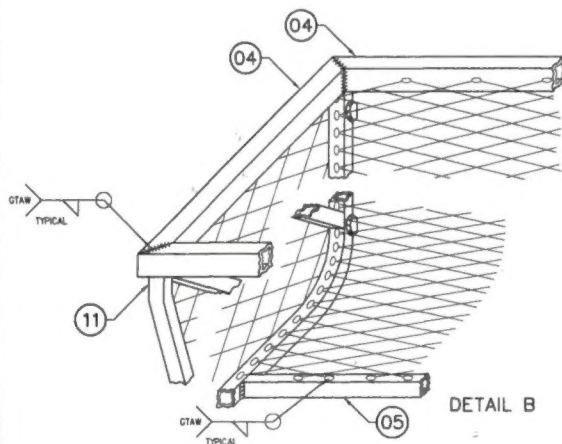
- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
 2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
 3. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 4. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.



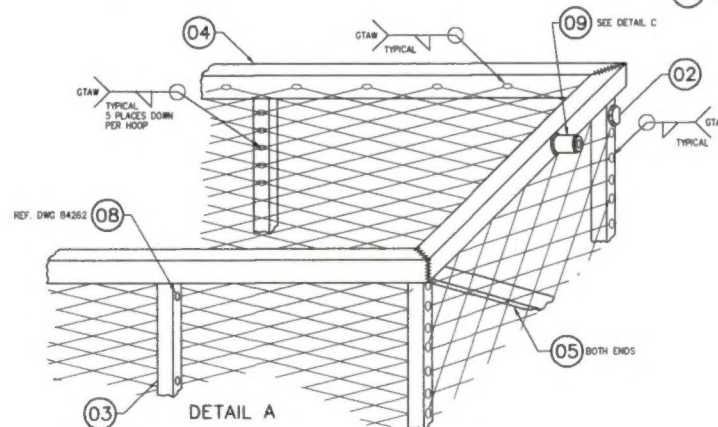
DETAIL C
SCALE 1:1
VIEW LOOKING AT FRONT RM OF BASKET



01 BASKET BODY ASSEMBLY



DETAIL B



DETAIL A

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	69822-01	11	AFT END HOOP	STEEL	COMMERCIAL	
A/R	3/4-16F	10	MESH			
1	49215-01	09	SPACER			
1	84262-01	08	HANDLE BRACKET ASSEMBLY			
		07				
		06				
A/R		05	TUBE	4130 STEEL COND. N	MIL-T-6736	0.5 X 0.035 SQR. TUBE
A/R		04	TUBE	4130 STEEL COND. N	MIL-T-6736	0.75 X 0.035 SQR. TUBE
3	49210-02	03	HOOP			
1	69821-01	02	FORWARD END HOOP			
1	69811-01	01	BASKET BODY ASSEMBLY			

LIST OF MATERIALS			
APPROVALS	DATE	AERO DESIGN LTD.	
DRAWN: JEFF CLARKE	11 APR 2006	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 280M	
CHECKED: E. BURGON		2013 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6B7	
		tel: (403) 265-8887 fax: (403) 265-8883 aerodesign@aerodesign.net	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		BELL 206L, 407 QUICK RELEASE CARGO BASKET BASKET BODY ASSEMBLY	
DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1		ANGLES ±1/2"	
SHEET 1 OF 1		SCALE 1:4	REV.
A1		69811	3



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity:

PN:

Aircraft:

Description:

Supplier:

Color:

WO#:

2

69823-02

206L/407

Mount Lug

Aero Design

N/A

2014-70

Model: N/A

PO# N/A